Work Order November-08-11						*76	255*		eregin in me						Page	e 1
Item ID: I Revision ID:	D350-748-20	)1			Ac	cept	*N9	$\cap$	<b>04</b> 0	100	<b>)</b> * s	Setup St	tart	*N	S1*	•
	Crosstube Inst	allation, H	igh Aft						-25			S	top	*N	S2*	<b>:</b>
Start Date: 0	08/11/2011	Start Q	ty: 1.00	*1	*		Cust	Item II	D:							
Required Date: 2	28/11/2011	Req'd (	<b>Qty:</b> 1.00	*1	*			omer:								
Reference:				•		. •										
Approvals:	Process Pla	n: M	L. J	Date: VI	T30/).	Cooling:		Da	te:		F		tart	*N	R1*	ŗ
	QC:		<u></u>	Date:	s	SPC (Y/N):		Da	te:			S	top	*N	R2*	•
Sequence ID/ Work Center ID		Operation Descript				Set Up/ Run Hours	To	(ID)	Tool#	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr	<u> </u>											***		
D350-748-241	F	<del></del>														
*100 *100* DC Document Control		DOCUME	ENT CONTRO Memo Photocopy b	L luefile & type label	s per PPPO	0.00	CHG002									i.
· 110						0.00							,	Þ	·	>
*110*		BENDING	6 MACHINE -	CROSSTUBES											/	
CNC Bend 2 CNC Alpha 160 Bend	er		Memo Bend tube as Folio FT	s per Dwg D350-74	8-241 using	0.00 CNC bender progr	ram D350A and									
120 *120*		QC15- Cro	osstube Dimen	sional Check		0.00										
QC Quality Control			Memo			0.00										_

Dart Aerospace Ltd	D	ar	t 🖊	le/	0	sp	ac	e	Ltd	
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W/O:		76855	WORK ORDER	WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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				•							

1//\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	1.1	ADV ADDED NAM AA	NICODRIANOE (NOD)			
Resoluti	ion: <u>Scrap</u>	Disposition: Scrap	QA: N/C Closed	1: <u>CF</u>	Date: [Z	2/10
Part No: <u>&gt;355-748-7</u>	PAR #:	_ Fault Category: ஊத் c	rear/costules NCR: Yes No	DQA:	_Date: <u>/2/0</u> /	3/16_

NCR:	1000	V	WORK OR	DER NON-CONFORMANC	E (NCR)	2928.10		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B  Action Description  Chief Eng	Sign & Date	Verification Section C	Approval Chief/Eng	Approval QC Inspector
12/2/25	世 110	tube Kinded During Bending on insine of tuke.  @ zozen from could.  R.C.		-Scrap + Destru No Replace	MO	12-1-25	120125	Solota

# \*76255\*

Page 2

November-08-11 7:48:33 AM D350-748-201 Accept \*N900040100\* Item ID: Setup Start **Revision ID:** Crosstube Installation, High Aft Item Name: **Start Date:** Start Qty: 1.00 08/11/2011 **Cust Item ID:** Required Date: 28/11/2011 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop SPC (Y/N): \_\_\_\_\_ Date:\_\_\_\_\_ Date: Sequence ID/ **Operation** Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Qty Number Stamp Code Qty 125 0.00 \*125\* HandFXtube 0.00 Memo \*\*\*Stress relief\*\*\* Hand Finishing Crosstubes Heat treat crosstube as per QSI010 4.3 Temp:\_ Start time: Finish time: 127 QC5- Inspect part completeness to step on W/O 0.00\*197\* OC 0.00

Quality Control

Memo

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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORDER NON-CONFORMAN					
DATE	OTED	Description of NC	Description of NC Corrective Action				Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector

Work	Order	ID	76255
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Quality Control

\*76255\*

Page 3

November-08-11 7:48:33 AM Item ID: D350-748-201 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Crosstube Installation, High Aft Start Qty: 1.00 **Start Date:** 08/11/2011 **Cust Item ID: Req'd Qty:** 1.00 **Required Date: 28/11/2011 Customer:** Reference: Run Process Plan: Date: \_\_\_\_\_ **Tooling:** Approvals: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID Description** Qty **Run Hours** Code Oty Number Stamp 130 0.00 Crosstubes \*120\* Crosstubes 0.00 Memo Crosstubes 1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs, Set-up drill table as per QSI 010 2-Deburr 3-Engrave Part # and Batch # as per Dwg D350-748-241 4-Remove all marks from tube within limits of D350-748-241 5- Apply a light coat of LPS3 on the interior of tube Batch: 140 QC6- Inspect dimensions to drawing 0.00 OC 0.00 Memo

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W/O:			W	ORK ORDER CHANG	ES				······································
DATE	STEP	PRO	OCEDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Wigi	,
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	٨:	Date: _	
	Re	esolution:	Dispositi	on:	_ QA: N/C CI	osed:		Date:	
NCR:	WORK ORDER NON-CONFORMANC			NCE (NCF	<b>?</b> )				
		Description of NC Corrective Action			on B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
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	Work Order ID 76255 November-08-11 7:48:33 AM			*762	255*						Page 4
Item ID: Revision ID:	D350-748-20	01		Accept	*N900	040	100	<b>)</b> * s	Setup Star	1 7	S1*
Item Name:	Crosstube Ins	tallation, High Aft							Sto	<sup>p</sup> *N	S2*
Start Date: Required Date:	08/11/2011 : 28/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I	ID:					
Reference:								-	54	.4 .	
Approvals:	Process Pla	nn:		Tooling:	D	ate:		ŀ	Run Stai	171	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		Outsource process-Cadp	plate per QSI017 4.1.9.1	0.00							
*150* Outsource3		Memo		0.00						. <u>-</u>	
Outsource process -	Cad plate	Magnetic P Cadium Pla Embrittle re Possibe Sup	at 375° for 5 hours article Inspect per ASTM tte per AMS-QQ-P-416B, C blief at 375° for 8 hours, Ch oplier: Southwest United In- difficate of Conformity is att	Class 1, Type 2 promate Treat dustries							
160		Receive & Inspect for D	amage & Mat'l Certs	0.00							
*160* Packaging		Memo		0.00						<del></del>	
Packaging		Ensure certi	ficate of conformity is attac	ched							
170		QC5- Inspect part comp	leteness to step on W/O	0.00							
*170*		Memo		0.00							

Quality Control

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W/O:			WC	RK ORDER CHANG	SES							
DATE	STEP	PRO	OCEDURE CHAI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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	:											
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes No DQA: Date:							
	R	esolution:	Disposition	ı:	QA: N/C (	Closed:		Date: _	·····			
NCR:		1	WORK ORDE	R NON-CONFORM	ANCE (NC	R)						
DATE	STEP	Description of NC	<u></u>		tion B	Verifi	cation	Approval	Approval			
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector			
	1	1										

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Page 5

November-08-11 7:48:33 AM

Item ID: Revision ID:	D350-748-20	01		Accept	*N900	040	100	<b>)*</b> s	etup Star	t *N	S1*
Item Name:	Crosstube Inst	tallation, High Aft							Stop	' <b>*N</b> .	S2*
Start Date: Required Date	08/11/2011 : 28/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1 *1		Cust Item I Customer:	D:					
Reference:					<u> </u>		_		lun Star		
Approvals:	Process Pla	ın:	Date:	Tooling:	D:	ate:		н		1/1	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:			Stop	` *N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180				0.00							
*180* SprayPaint		SprayPaint Memo		0.00							
Spray Painting		1-Prime ins	ide crosstube as per side of Tube as per I								
190		QC14- Inspect Spray Pa	int	0.00							
*190*											
QC		Memo		0.00							
Quality Control		Then,Wrap	in plastic bag to pro	ect from scratches							
200				0.00							
*200*		Crosstubes									
Crosstubes		Memo		0.00							
Crosstubes				insert screw and washer							

2-Install Abraision strips as per Dwg D350-748-241 & QSI 035.
3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-

LBS

W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
								Prod Mgi						
									Ì					
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	Date: _								
		esolution:												
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	₹)								
		Description of NC	Corrective Action Section		Verific	cation	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section C		Chief Eng	QC Inspector					
							i							
						1								

Work Orde November-08-1							Page 6				
Item ID: Revision ID:	D350-748-20			Accept	*N900	040	100	<b>)</b> *	Setup Sta	1.71	S1*
Item Name: Start Date: Required Date: Reference:	08/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				· ^N	S2*
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:		1	Run Sta Sto	171	R1* R2*
Sequence ID/ Work Center II	)	Operation Description QC5- Inspect part compl	eteness to sten on W/O	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*210* QC Quality Control		Memo		0.00							
220		Pick Kit		0.00							
*220* Packaging Packaging		Memo		0.00							

230

QC4- 100% Inspect kits for completeness

0.00

\*230\*

Memo

0.00

Quality Control

W/O:			W	ORK ORDER CHANG	iES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes I	No DQA:	Date:						
Reso		olution:	Dispositio	n:	QA: N/C Closed: Date:								
			WORK ORD	ER NON-CONFORM	ANCE (NCR)	)							
DATE	STEP	Description of NC	Initial		ion B Sign &	Verification		Approval					
		Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector					
					· ·								

Work Orden				*762			the transfer of the transfer o	Page 7			
Item ID: Revision ID: Item Name:	D350-748-20 Crosstube Inst	01 tallation, High Aft		Accept	*N900	<b>040</b>	100	)*	Setup Sta	I VI	S1* S2*
Start Date: Required Date: Reference:	08/11/2011 28/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:			Run Sta	1/1	R1*
	QC:		Date:	_	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*740* Packaging		Packaging <b>Memo</b>		0.00							
Packaging		Identify and Location: PPP Rev:_	pack for shipping as per	PPPD350-748-201							
250		QC21- Final Inspection -	- Work Order Release	0.00							

0.00

Memo

Quality Control

p12-03-12

W/O:			WC	RK ORDER CHANG	ES										
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
*****							· · · · · ·	1 Tod Mg							
Part No	·	PAR #:	Fault Cate	gory:	NCR: Yes	Date:									
	Re	esolution:	Disposition	n:	_ QA: N/C Cld	osed:		Date: _							
NCR:			WORK ORDER NON-CONFORMANCE (NCR)												
DATE	OTED	Description of NC	Corrective Action Section		Verifica	tion	Approval	Approval							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector						
,															

ST281 2418 498 108696

110768 62 118386 858 118966 1000

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NAS1149D0363J Purchased 0.0000 200 Each No

\*AN960.JD10\*

Washer

AN960JD10

W/O:			V	SES					
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:		V	VORK OR	DER NON-CONFORM	ANCE (NC				
DATE	STEP	Description of NC	luiai at		tion B		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Dat		tion C	Chief Eng	QC Inspector
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Picklist Print November-08-11 7:48:37 AM									Page 2
Work Order ID: 76255	A	*7	6255*						
Parent Item: D350-748-201  Parent Item Name: Crosstube Instal	lation, High Aft	*D	350-748-2	<b>N1</b> *			art Date: 08 tart Qty: 1.0		Required Date: 28/11/2011 Required Qty: 1.00
D2856-400	Manufactured	No		200	f	304.0945	1.181	1.243158	
*D2856-400* Abraison Strip							**		
·			Location ST403 68076 ST409 63735 71164	30	c Oty 0.3149 0.3149 3.7796 0.6696 87.11	Loc Code			
1- cut as per dwg D2856 D3502-1 *D3502-1*	Manufactured	No	73491	200	216 Each	37.0000	2 **	2	
Support			Location ST063 68951 72129 73419	<u>Lo</u>	37 3 14 20	Loc Code			
MS21920-20 *MS21920-20* Clamp (per MIL-DTL-8783C)	Purchased	No	/3419	200	Each	72.0000	2 **	2	
r vr			LG050 116799 118649 119386	<u>Lo</u>	72 10 12 50	Loc Code			

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
									Prod Mgr	,				
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR	Date:								
	Re	solution:	Dispositio	n:	_ QA:	N/C Clo	sed:		Date:					
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR								
DATE	CTED	Description of NC	Corrective Action Secti	ion B		Verific	cation	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n Sign & Date			on C	Chief Eng	QC Inspector				
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Picklist Print November-08-11 7:48:37 AM									Page 3
Work Order ID: 76255		*76	255*						
Parent Item: D350-748-201			350-748-2	0∩1*					
Parent Item Name: Crosstube Installa	ation, High Aft	1 7.	1:1U-140-/	( )		Start	Date: 0	8/11/2011	Required Date: 28/11/2011
	, 6						t Qty: 1		Required Qty: 1.00
MS27039-1-10	Purchased	No		200	Each	304.0000	1	1	
*MS27039-1-10*						*	*		
			Location	<u>L</u> .	oc Qty	Loc Code			
			ST291		304				_
			118612		154				_
			119307		100				<del></del>
			119531		50				_
AN4-41A	Purchased	No		220	Each	305.0000	8	8	
*AN4-41A*						*	*		
			<b>Location</b>	<u>L</u>	oc Qty	Loc Code			
			ST360		305				
			115108		3				
			115705		7				
			116191		20			<del></del>	
			117619		50 25				_
			117795 118451		50				
			118838		50			-	<del></del>
			119328		100				_
AN4-6A	Purchased	No		220	Each	5,476.000	16	16	
*AN4-6A*						*	*		
			<b>Location</b>	<u>L</u>	oc Qty	Loc Code			
			ST356		476				_
			118838		276				-
			119127		200				<del></del>
			ST516		5000				
			119017		5000				<u> </u>

W/O:			W	ORK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·		
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes			
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NCR:		\	WORK ORE	DER NON-CONFORMA	NCE (NCR)	<del></del>		
DATE	0755	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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<b>Picklist Prin</b> t November-08-11 7										Page
Work Order ID: 7	6255		*7(	6255*						
Parent Item: D	350-748-201			350-748-2	0∩1*					
Parent Item Name:	Crosstube Installation	on, High Aft	1 )	.5:3U-140-2	()		St	art Date: 08	8/11/2011	Required Date: 28/11/2011
								tart Qty: 1.		Required Qty: 1.00
AN5-32A		Purchased	No		220	Each	195.0000	4	4	Acquired Qey. 1100
*AN5-32	Α*	Furchased	110		220	Edeli	193.0000	**	<del></del>	
,,,,				<b>Location</b>	Lo	oc Oty	Loc Code		ı	
				ST339	_	195				
				118422		20				
				118628		50				_
				118983		25				_
				119328		100				_
N960JD416	NAS1149D0463J	Purchased	No		220	Each	0.0000	32	32	
*AN960.1	ID416*			,				**		
N960JD516	NAS1149D0563J	Purchased	No		220	Each	0.0000	8	8	
*AN960.1	ID516*							**		
3500-1		Manufactured	No		220	Each	16.0000	4	4	
*D3500-	1*							**		
				<b>Location</b>	<u>L</u> c	e Oty	Loc Code			
				ST424		4				_
				70695		4				_
				ST427		12				_
				73407		12				_
03501-1		Manufactured	No		220	Each	237.0000	16	16	
*D3501-	1*							**		
				<b>Location</b>	<u>Lo</u>	oc Qty	Loc Code			
				ST063		237	•			_
				67757		4				<del>_</del> .
				70682		100				_
				73391		133	4			_
November-08-11 7				Chan D	acket Print		<del></del>			Pag

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DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C Cld	sed:	Date: _	
NCR:		•	WORK ORDI	ER NON-CONFORMA	NCE (NCR	)		
DATE	STEP	Description of NC		Corrective Action Section	n B   Sign &	Verificati		
DATE	0,2,	Section A	Initial Action Descript Chief Eng Chief Eng		Date	Section (	C Chief Eng	QC Inspector
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Picklist Print November-08-11 7:48:37 AM				***************************************					Page 5
Work Order ID: 76255  Parent Item: D350-748-201  Parent Item Name: Crosstube Insta	llation, High Aft		6255* 350-748-2	201*			t Date: 0	8/11/2011 00	Required Date: 28/11/2011 Required Qty: 1.00
MS21042L4 *MS21042L4* Nut	Purchased	No		220	Each	12,685.00	24 **	24	
			Location ST300 117441 117601 118451 118927 ST516 119017 ST518	<u>Lo</u>	1685 51 532 133 969 6000 6000 5000	Loc Code			
*MS21042L5 *MS21042L5* Nut	Purchased	No		220	Each	2,358.000	4 <b>**</b>	4	
			Location ST300 116105 116548 117611 118179	Loc	858 5 43 62 496	<u>Loc Code</u>			  

November-08-11 7:48:37 AM

252

1500

1500

118910

119109

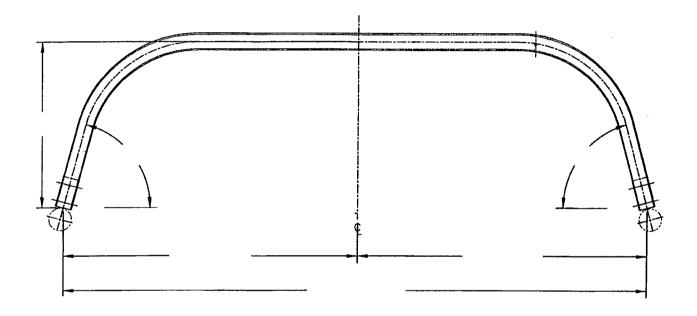
ST518

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector Approval OC Inspector Part No: \_\_\_\_\_\_ PAR #: \_\_\_Fault Category: \_\_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_\_\_\_

Resolution:		esolution:	Dispositi	on:	QA: N/C Clos	sed:	Date: _	
NCR:								
		Description of NC		Corrective Action Section	В	Verification	Approval Chief Eng	A 1
DATE	STEP	Section A	<b>Initial</b> Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
						-		
								:

DART AEROSPACE LTD	Work Order:	76255		
Description: Crosstube High Aft (AS350/355)	Part Number:	D350-748-201		
Inspection Dwg: D350-748-241 Rev: E		Page 1 of 1		

Required Dimension	Min	Max	
Height	31.22	31.48	
1/2 Span	40.77	41.03	
Angle	75	77	
Total Span	81.54	82.06	



 Comments	
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QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	1
В	10.08.23	Dwg Rev updated	KJ	IF
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W/O:			WC	RK ORDER CHANG	ES		<u> </u>		
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Item	Qty -241	Part Number	Description					
1	Х	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT					
2	1	D6015-125	CROSSTUBE (OR D6018-125)					
3	2	D3502-1	SUPPORT					
4	2	D2856-400-710	ABRASION STRIP					
5	1	AELS-1032-225	INSERT					
6	1	NAS1149D0363J	WASHER (OR AN960JD10)					
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)					
8	1	MS27039-1-10	SCREW					

### **GENERAL NOTES:**

1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6018-125

FINISHED LENGTH = 122,700±0.06

2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2 CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 29.85 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.

11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.

12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE. CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.

- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES. NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

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WORK ORDER H.C.J.

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F	TWIST	LIMIT (A8-1,	TION (B8-1) PER PAR 09-040, ADD C1-3), ADD D6015-125 OPTION I NOW MACHINED (D1-4)	СР	10.11.23		
E	STAND	ARDS; REL	NOTES; UPDATE TO CURRENT OCATED FLAG #6 PER PAR 08-046 LERANCES (ZN C6-3, D2-3)	RF	09.09.30		
D	MAG. F	ARTICLE AN	ID CAD PLATE AS MFD.	CP	06.10.31		
С	ADD C	AD PLATING		CP	06.08.14		
В	ADD D	5018-125 & P	RIME AND PAINT	CP	06.06.30		
A	NEWIS	SUE		CP	06.03.31		
REV.			DESCRIPTION	BY	DATE		
DESIGN		P	DART AEROSP	ACE	LTD		
DRAWN		qp	HAWKESBURY, ONTAR				
CHECKE	D	1	DRAWING NO.		REV. F		
MFG. APPR.		E	D350-748-241	350-748-241 SHEET			
APPRO\	√ED	-144	TITLE	TITLE			
DE APPR.			CROSSTUBE (AS 350/355 HI AFT)				
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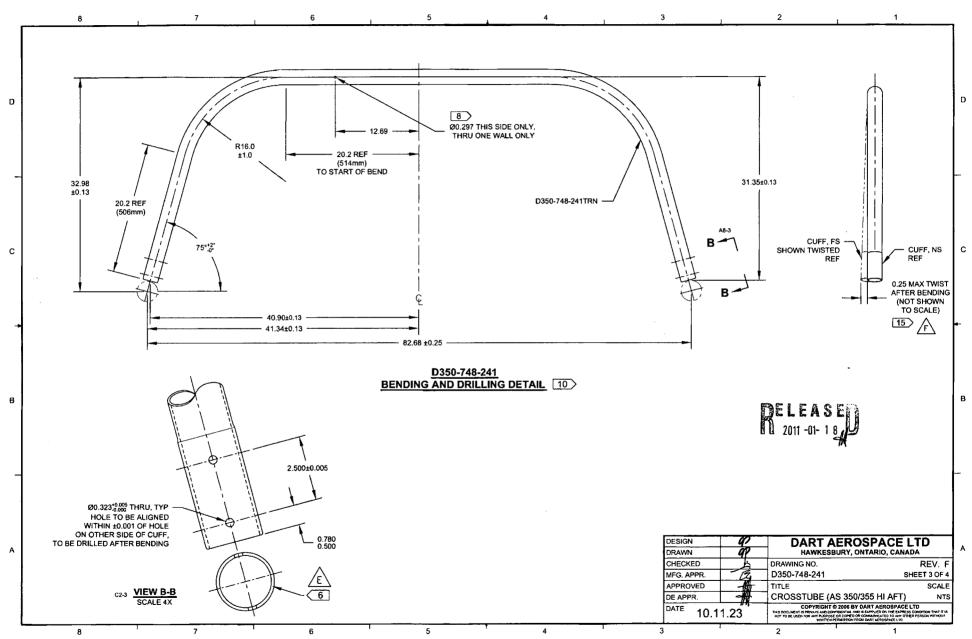
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8 6 14 D3502-1 SUPPORT MS21920-20 CLAMP 2 PL 12> . D D2856-400-710 ABRASION STRIP, 2 PL 4.00 TO ABRASION STRIP REF D350-748-241 BENT TUBE INSTALL AFTER FINISH: AELS-1032-225 INSERT NAS1149D0363J WASHER MS27039-1-10 SCREW С D350-748-241 ASSEMBLY DETAIL В В MS21920-20 CLAMP REF D3502-1 SUPPORT DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA D2856-400-710 ABRASION STRIP DRAWN CHECKED DRAWING NO. REV. F MFG. APPR. D350-748-241 SHEET 2 OF 4 SECTION A-A D4-2 APPROVED TITLE SCALE 4X SCALE DE APPR. CROSSTUBE (AS 350/355 HI AFT) COPYRIGHT © 2006 BY DART AEROSPACE LTD
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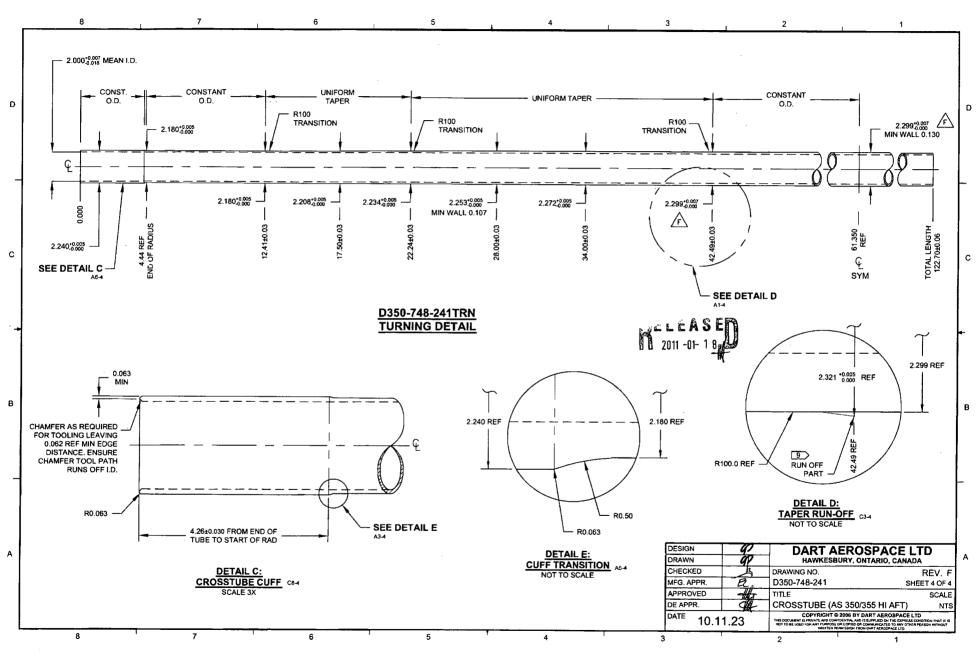
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